



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-021
Job Sheet 176041



Part No: D3391-021

Job Qty: 1 ea

Part Name: Fwd Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3391 REV J SHEETS 4,5 IPP A 05.09.13 New issue KJ/JLM IPP B IPP C IPP D 07.03.13 rev F dwg EC IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD IPP Rev:f ECN 1056 07-11-12 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/23/18	5/23/18	0.00	0.00	Start Up Skidtubes-1		M/6/18
100	Skidtubes	1 pcs	5/23/18	5/23/18	0.00	0.82	Skidtubes-4		M/6/18
110	CNC Bend Skidtubes	1 pcs	5/23/18	5/23/18	0.00	1.00	CNC Bend Skidtube		M/6/18
120	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC5		BE
130	CNC Vertical Machining	1 pcs	5/23/18	5/23/18	2.21	1.00	HAAS1-3		K/18-05-20
140	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC2 Machining-2		K/18-05-20
150	Mill Conv	1 pcs	5/23/18	5/23/18	0.00	0.27	Mill Conv 1		18/5/20
160	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC2 Machining-2		18/5/20
170	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC8 Machining-2		18/05/23
180	Skidtubes	1 pcs	5/23/18	5/23/18	0.00	0.82	Skidtubes-4		J.Y. DAS
190	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC5		38
200	HandFinish	1 pcs	5/23/18	5/23/18	0.00	0.33	HandFinish1		SA 18-06-05
210	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC7-2		BE M/6/18
220	Skidtubes	1 pcs	5/23/18	5/23/18	0.00	0.82	Skidtubes-4		M/6/18-06-07
230	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC5		38
235	HandFinish	1 pcs	5/23/18	5/23/18	0.00	0.33	HandFinish2		SA 18-06-12
241	SprayPaint	1 pcs	5/23/18	5/23/18	0.00	0.99	Spray Paint		Jim 13/06/2018
242	Outsource	1 pcs	5/23/18	5/23/18			ATE003-VC		
250	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC14		M/18-7-11
254	HandFinish	1 pcs	5/24/18	5/24/18	0.00	0.33	HandFinish4		M/18-7-11
256	QC	1 pcs	5/24/18	5/24/18	0.00	0.00	QC5		M/18-7-11
260	Packaging	1 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1		M/18-7-11
280	QC21-SA	1 Ea	5/24/18	5/24/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut as per dwg.

Descriptions: 110 - Bend as per Dwg D3391 Using Bend Prog 3391021

130 - 1-Machine as per Folio FA590 Rev. ____ & Dwg D3391 Rev. ____

150 - Drill X1 Aft cap as per Dwg D3391 .1875" dia

180 - 1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step 2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A") 6-Deburr & Scribe Batch number Inside aft.end. 7-Transfer drill D3391-021 with D3391-023

220 - 1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: M137623 exp. date: 10-09 cure time

SPRAY PAINT 241 138747: PAINT 138863

Plex 4/16/18 8:30 AM Dart.lajeunesse.marie

12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary
235 - AND REALODINE AS PER QSI 005

004326

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6013-047	Skidtube Material	1 Ea (1 ea)	90-Start up Operation	B86064
D3670-4-200	Bushing	4 Ea (4 ea)	220-Skidtubes	S021404
AELS-1032-225 Y	Insert (A654-1032-225)	10 Ea (10 ea)	254-HandFinish	S058130
AN3C4A	Bolt	10 Ea (10 ea)	254-HandFinish	S068642
D3401-041	Tow Cap Assembly	1 Ea (1 ea)	254-HandFinish	S071282
D3672-1	Washer, Phenolic	4 Ea (4 ea)	254-HandFinish	MF159902
D4095-051	Wearpad Fwd	1 Ea (1 ea)	254-HandFinish	F150074
NAS1149C0332R	Washer	10 Ea (10 ea)	254-HandFinish	S0656493

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6013-047	1	49	0
220-Skidtubes	D3670-4-200	4	48	0
254-HandFinish	AELS-1032-225	10	0	0
	AN3C4A	10	2,277	0
	D3401-041	1	0	0
	D3672-1	4	1,071	0
	D4095-051	1	22	0
	NAS1149C0332R	10	6,563	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S064635



Part: D3391 - 021

Job No: 176041

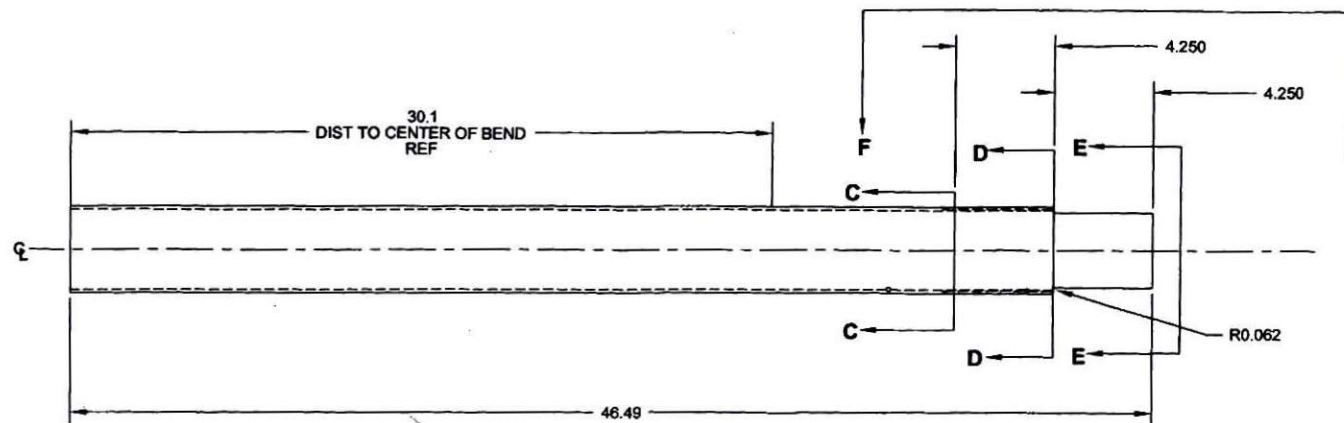
Serial No/Batch: S064635

Revision:

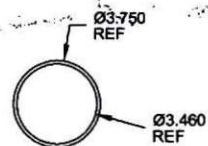
Inspector:

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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

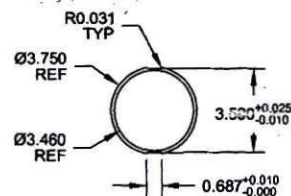
Date: 04/24/18



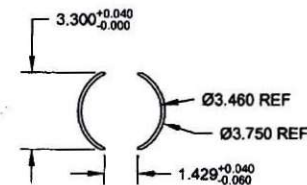
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



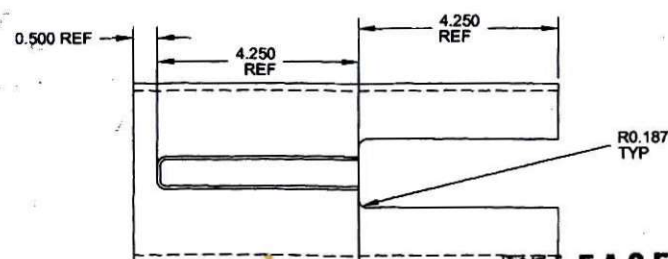
SECTION C-C



SECTION D-D



SECTION E-E



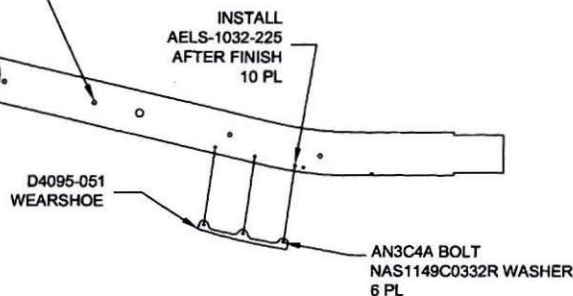
VIEW F-F
SCALE 2X

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	22	D3391	SHEET 5 OF 11
APPROVED	21	TITLE	SCALE
DE APPR.	21	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

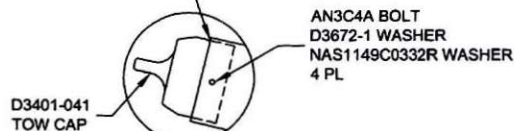
INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



D3391-021 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL

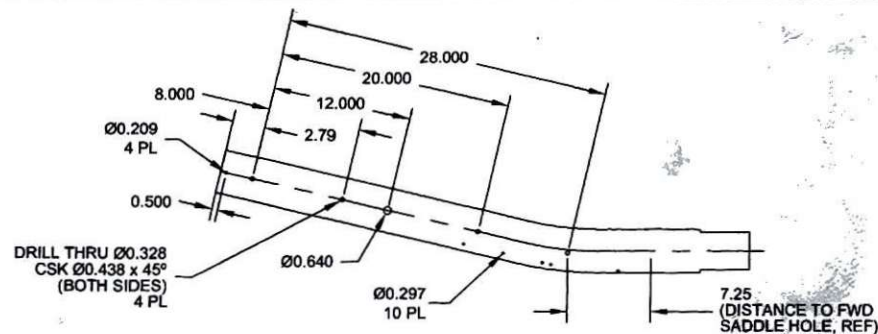
SEAL WITH
SIKAFLEX-241/-291



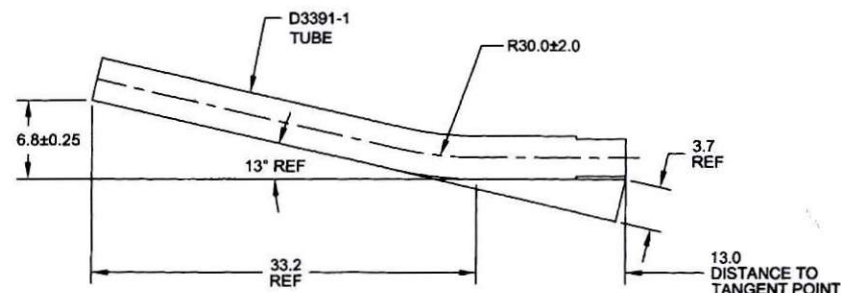
DETAIL B
SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-021 DRILLING DETAIL



D3391-021 BENDING DETAIL
(MAKE FROM D3391-1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176041 MJS
1804-16

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DR	D3391	SHEET 4 OF 11
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DE APPR.	BY	412 FLOAT SKIDTUBE	NTS
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